



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4292-1

Job Sheet 175297



Part No: D4292-1

Job Qty: 8 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/2/18

Job Tracking No:

Due Date: 4/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	4/12/18	4/12/18	0.00	0.00	Start Up Machining-2		J.F.
100	Bandsaw	8 pcs	4/12/18	4/12/18	0.00	0.68	Bandsaw1		J.F.
110	CNC Vertical Machining	8 pcs	4/12/18	4/12/18	0.51	16.45	HAAS 5 Axis		J.F. 18-04-11
120	QC	8 pcs	4/12/18	4/12/18	0.00	0.00	QC2 Machining-2		J.F.
130	QC	8 pcs	4/12/18	4/12/18	0.00	0.00	QC8 Machining-2		J.F. 18-04-12
140	HandFinish	8 pcs	4/12/18	4/12/18	0.00	0.45	HandFinish1		J.F. 18-04-16
145	Powdercoat	8 pcs	4/12/18	4/12/18	0.00	0.59	Powdercoat1		J.F. 18-4-16
150	QC	8 pcs	4/12/18	4/12/18	0.00	0.00	QC3		J.F.
151	Small Fab	8 pcs	4/13/18	4/13/18	0.00	0.36	Small Fab-6		J.F.
152	QC	8 pcs	4/13/18	4/13/18	0.00	0.00	QC5		J.F.
180	Packaging	8 pcs	4/13/18	4/13/18	0.00	0.00	Packaging3-2	51333	APR 17 2018
190	QC21-SA	8 Ea	4/13/18	4/13/18	0.00	0.00	QC21		J.F.

Part Op 100 - Cut Blank to 6.250" ****GRAIN DIRECTION MUST BE ALONG 4.00*****

Descriptions: 110 - 1-Machine per folio FB002

145 - MASK THREADED HOLE

151 - INSTAL HELICOIL

21 APR 17 2018

S059 504 M 138760 START 3:40 O.V.T. 3:00 FINISH: 4:10.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B4.000x4.000	7075-T73 Bar 4.0 X 4.0 Grain Direction Along 4"	4.1600 ft (.52 ea)	90-Start up Operation	
MS21209F1-10	Heli Coil	8 Ea (1 ea)	151-Small Fab	S044218

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B4.000x4.000	4	44	0
151-Small Fab	MS21209F1-10	8	49	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
---------	-------------	------------------	--------	------	------------------



Container No: S059879



Part: D4292-1

Job No: 175297

Serial No/Batch: S059879

Revision:

Inspector:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/11/18

1	Fitting	0.063Inches ± 0.010	0.073 0.053	csk
2	Fitting	0.250Inches + 0.030 - 0.010	0.280 0.240	
3	Fitting	0.125Inches + 0.030 - 0.010	0.155 0.115	
4	Fitting	2.950Inches ± 0.030	2.980 2.920	
5	Fitting	0.275Inches ± 0.010	0.285 0.265	
6	Fitting	0.800Inches ± 0.010	0.810 0.790	
7	Fitting	0.825Inches ± 0.010	0.835 0.815	
8	Fitting	0.375Inches ± 0.010	0.385 0.365	
9	Fitting	0.310Inches ± 0.030	0.340 0.280	
10	Fitting	0.880Inches ± 0.030	0.910 0.850	
11	Fitting	0.663Inches ± 0.010	0.673 0.653	
12	Fitting	0.381Inches + 0.000 - 0.001	0.381 0.380	
13	Fitting	1.125Inches ± 0.010	1.135 1.115	
14	Fitting	1.063Inches ± 0.010	1.073 1.053	
15	Fitting	3.440Inches ± 0.030	3.470 3.410	
16	Fitting	2.450Inches ± 0.010	2.460 2.440	
17	Fitting	1.325Inches ± 0.010	1.335 1.315	
18	Fitting	0.300Inches ± 0.010	0.310 0.290	
19	Fitting	1.200Inches ± 0.010	1.210 1.190	
20	Fitting	2.840Inches ± 0.030	2.870 2.810	
21	Fitting	0.190Inches ± 0.030	0.220 0.160	
22	Fitting	5.860Inches ± 0.030	5.890 5.830	
23	Fitting	5.990Inches ± 0.030	6.020 5.960	
24	Fitting	0.272Inches + 0.006 - 0.001	0.278 0.271	
25	Fitting	0.266Inches + 0.006 - 0.001	0.272 0.265	
26	Fitting	1.750Inches ± 0.030	1.780 1.720	
27	Fitting	0.250Inches ± 0.030	0.280 0.220	Radius
28	Fitting	0.060Inches ± 0.030	0.090 0.030	Radius
29	Fitting	4.875Inches ± 0.010	4.885 4.865	
30	Fitting	0.493Inches ± 0.010	0.503 0.483	
31	Fitting	0.765Inches ± 0.010	0.775 0.755	c-bore
32	Fitting	0.250Inches + 0.030 - 0.010	0.280 0.240	
33	Fitting	0.680Inches ± 0.010	0.690	

			0.670	
34	Fitting	2.250Inches ± 0.010	2.260 2.240	
35	Fitting	4.500Inches ± 0.010	4.510 4.490	
36	Fitting	1.275Inches ± 0.010	1.285 1.265	
37	Fitting	0.031Inches ± 0.010	0.041 0.021	Radius
38	Fitting	0.130Inches ± 0.030	0.160 0.100	Radius
39	Fitting	1.650Inches ± 0.030	1.680 1.620	
40	Fitting	1.421Inches ± 0.010	1.431 1.411	

Plex 4/4/18 10:23 AM Dart.Gagnon.Michelle